W	ork	Order	ID	71031
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Tuesday, June 21, 2011 10:36:17 AM



Page 1

Item ID:

D3208-9

Accept



Setup Start



Stop

Revision ID: Item Name:

Doubler

Required Date: 6/27/2011

6/21/2011

Start Qty: 6.00 Req'd Qty: 6.00

Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date://-06-

Tooling:

Date:

Run

Start

Stop



QC:

Date:

SPC (Y/N):

Date:

Tool ID

Reject

Insp.

Sequence ID/ **Work Center ID**

Operation **Description** Set Up/ **Run Hours**

Tool # Plan

Code

Reject Accept Qty Qty

Number

Stamp

Draw Nbr

Revision Nbr

D3208 Rev A1

100

Waterjet

FLOW WATER JET

Memo

0.00

□Dwg Rev: A(□Prog Rev: A(□2-

0.00

1311-6-22

FLOW CNC Waterjet OBO. 4606

1-Cut as per Dwg D3208

Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

1B11-6-25

Quality Control

120

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

Dail Aci	ospace	Llu								*
W/O:			W	ORK ORDER CHANG	GES			<u>-</u>		•
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:			NCR	: Yes	No DQ	A:	Date:	
			Disposition: Dat							
NCR:		V	VORK OR	DER NON-CONFORM	ANCE	(NCF	₹)			
D.4.T.C		Description of NC Corrective Action Section B			tion B	•••	Verific	ation	Approval	Approval
DATE	STEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	& Secti		Chief Eng	QC Inspector
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Work Order ID 71031

Tuesday, June 21, 2011 10:36:17 AM



Page 2

Item ID:

D3208-9

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 6/27/2011

Doubler

Start Qty: 6.00 6/21/2011

Req'd Oty: 6.00

Cust Item ID:

Customer:

Tool ID

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

Date:

SPC (Y/N):

Set Up/

< Run Hours

Date:

Stop

Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo Deburr

Memo

0.00

Tool # Plan

Code

Accept Qty

Reject Reject Qty

Insp. Number Stamp

140

HandFinish Hand Finishing Chemical Conversion Coat per QSI005 4.1

0.00

0.00

150

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10 & Mulog123

Dail Aci	Ospace	Liu								
W/O:			WC	ORK ORDER CHANG	GES			· -		,
DATE	STEP	PRO	OCEDURE CHA	NGE	By Date			Qty	Approval QC Inspector	
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Part No					NCR: Yes No DQA: Date:					
	Re	esolution:	Dispositio	n:	QA:	N/C Clo	sed:	,	Date: _	
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR))			
DATE	STEP Description of NC		Corrective Action Section B			verificat			ion Approval	Approval
DATE	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date		ion C	Chief Eng	QC Inspector
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Work Order ID 71031

Tuesday, June 21, 2011 10:36:17 AM



Page 3

Item ID:

D3208-9

Doubler

Item Name: **Start Date:**

Revision ID:

6/21/2011

Required Date: 6/27/2011

Start Qty: 6.00 **Req'd Qty:** 6.00 Accept



Date:

Setup Start



Stop

Cust Item ID:

Customer:

Reference:

A	nn	rov	val	e:
	ทม	יטוו	v a i	ъ.

Process Plan:

Operation

Description

Date:

Tooling:

Date:

Run

Start



Stop

Sequence ID/

Work Center ID

160

Packaging

Packaging

Memo

Memo

Date:

0.00

SPC (Y/N):

Set Up/

Run Hours

0.00

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

170

QC **Ouality Control** QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location: ST 202

0.00

0.00

11/6/27 ff MF (1-06-24

Dail Aci	ospace	E.C.							
W/O:			WC	RK ORDER CHANGE	S	· · · · · ·			1 _{1,}
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR))			
DATE	STEP	Description of NC	Description of NC Corrective Acti		vei			Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
_									

Picklist Print

Tuesday, June 21, 2011 10:36:23 AM

Work Order ID: 71031

D3208-9 Parent Item:

Parent Item Name: Doubler



Start Date: 6/21/2011

Required Date: 6/27/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP A□04.06.09□New issue□KJ/RF□

IPP Rev:B Now on Waterjet 07-08-29 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Locatio	•	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No		100	sf	110.1000	0.1444	0.912			
									1R 11-6	- 22		

2024-T3 .080 sheet

Location	Loc Oty	Loc Code	
MAT022	110.1		
105411	6		
109424	4		
110347	0.5		
110908	3		
112331	3		
113796	7		
114025	17.2		114025
116604	5.8		
117392	63.6		
and the second s			

Page 1

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W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:	PAR #:	Fault Cate	jory:	_ NCR: Yes I	No DQ	A:	_ Date: _				
	R	esolution:	Disposition	1:	_ QA: N/C Clo	sed:		Date: _				
NCR:		,	WORK ORDE	ER NON-CONFORMA	NCE (NCR)		-				
DATE	STEP	Description of NC	·		Section B Verif			Approval	Approval			
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	_											
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DART AEROSPACE LTD	Work Order:	71031		
Description: Doubler	Part Number:	D3208-9		
Inspection Dwg: D3208 Rev: A1		Page 1 of 1		

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.500	+/-0.010	4.509	100		V (Bo2	
2.46	+/-0.030	2,459	×		V	
4.125	+/-0.010	4,135	*		V	
R0.250	+/-0.010	1750	×		R.C.	
_						
				-		
				_		

Measured by:	B	Audited by:	Prototype Approval:	N/A
Date:	11-6-35	Date: (104/72	Date:	N/A

Rev	Date	Change	Revised by	Approy∉d
A	05.02.17	New Issue	KJ/JLM	
				

	Johann									
W/O:			W	ORK ORDER CHAI	NGES					
DATE	STEP	PRO	PROCEDURE CHANGE			Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										
Part No: PAR #:		Fault Cat	egory:	NCR:	Yes N	o DQ	A:	_ Date: _		
Resolution:			Dispositi	on:	QA: N	VC Clos	sed:		Date: _	
NCR:			WORK ORE	DER NON-CONFOR	MANCE (NCR)				
DATE	STEP	Description of NC		Corrective Action Section B Verification		ation	n Approval Approv			
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	on S	Sign & Date	Section C	on C	Chief Eng	QC Inspector
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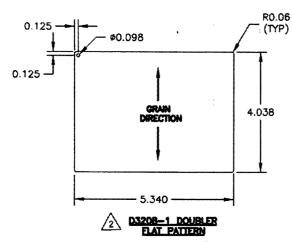


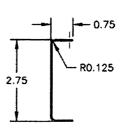


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04.01.27		DOUBLER	1:3



04.01.27 NEW ISSUE 04.05.25 MANGE DIM ; NOTE 3) CHANGE

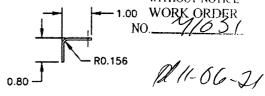




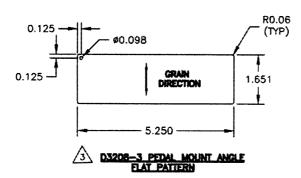
D3208-1 DOUBLER BEND DETAIL

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY

SUBJECT TO AMENDMENT WITHOUT NOTICE



D3208-3 PEDAL MOUNT ANGLE BEND DETAIL



NOTES:

1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)

3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)

4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)

5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

7) ALL DIMENSIONS ARE IN INCHES

3) MATERIAL: 6061-TL (QQ-A-250/11) 0.063" THICK (M6061T65.063)



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W/O:			W	ORK ORDER CHAN	NGES	 				
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: PAR #:		PAR #:	Fault Ca	egory:	NCR:	Yes N	lo DQ	A:	Date: _	
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NCR:			WORK OR	DER NON-CONFOR	MANCE	(NCR)				
DATE	STEP	Description of NC			Section B	Sign &		ation	Approval Chief Eng	Approval
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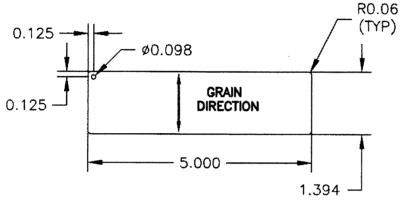


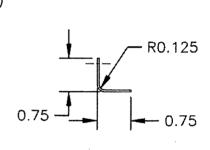


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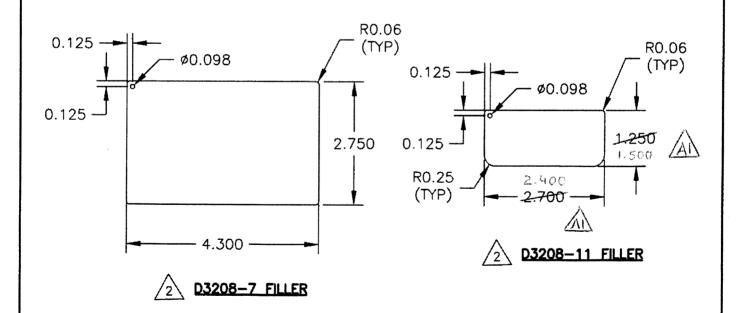
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D3208-5 MOUNT ANGLE

D3208-5 MOUNT ANGLE BEND DETAIL



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DATE	STEP	PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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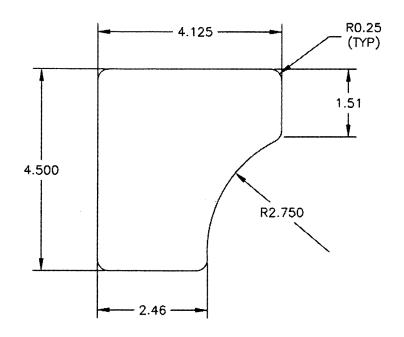




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D3208-9 DOUBLER

Dart Ac	erospace	Ltd
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